

**Work Order ID 62847**

Tuesday, October 12, 2010 11:41:38 AM



Page 1

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPPD350-607-043A CHG001

S 10/10/26

H for BG 10-10-26  
LABEL ONLY

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/10/26

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607

Seal Support Gusset with Sikaflex -291

Batch: M115714

Exp Date: 11/09

S 10/10/21 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				1			10/10/21
140  Packaging Packaging	Pick Kit  Memo	0.00  0.00							10/10/2010
150  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							8 10/10/26

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-607-043A

Location: *MVA*

170

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*10/10/27**10/10/27**MF**10-10-27*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Tuesday, October 12, 2010 11:41:42 AM

Page 1

Work Order ID: 62847

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC IPP RevC: as per dwg revC DD 10.01.18 verified by:EC IPP rev:D as per ecn10-545 DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2728-3		Manufactured	No			110	Each	0.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Part Logo Label

D350-607-241



Basket Clamp Assembly

6/12/2011

Manufactured No

140

Each

2.0000

1

1

62871 10/10/25

Location

Loc Qty

Loc Code

FG022

2

61681

2

D2022-101

Manufactured No

110

Each

94.0000

5

5



Spacer

10/10/25

Location

Loc Qty

Loc Code

ST504

94

50746

23

52325

11

61990

60

D2221

Manufactured No

110

Each

0.0000

1

1



350 Basket Base

D2258-200

Manufactured No

110

Each

12.0000

1

1



Placard 200lb

B62853 10

10/10/25

10/10/25

Location

Loc Qty

Loc Code

ST505

12

61760

12

1

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 62847

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2530 Manufactured No  
Handle Weldment

110 Each 12.0000



1 10/12/2010

Location	Loc Qty	Loc Code
ST506	12	
60206	2	
61224	10	

D2535 Manufactured No  
Spring

110 Each 72.0000



2 2 10/12/2010

Location	Loc Qty	Loc Code
ST504	72	
58331	72	

D2537 Manufactured No  
Bushing

110 Each 54.0000



2 2 10/12/2010

Location	Loc Qty	Loc Code
ST504	54	
59122	12	
59423	12	
62393	30	

D2931 Manufactured No  
Bumper

110 Each 784.0000



2 2 10/12/2010

Location	Loc Qty	Loc Code
ST504	784	
46064	784	

D2989-041 Manufactured No  
Basket Lid Assembly

110 Each 0.0000



1 1 10/12/2010

B62856 (12)

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 62847



Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2989-043 Manufactured No



Basket Lid Assembly

D350-607-143 Manufactured No



Automatic Lid Opener Installation

110 Each 0.0000 1 1

110 Each 1.0000 1 1

B62859 @ 10/12/2010

B63008 10/12/2010

Location Loc Qty Loc Code

FG032 1  
54041 1

AN3-16A Purchased No



Bolt

110 Each 98.0000 2 2

Location Loc Qty Loc Code

ST352 98  
114752 98

AN4-13A Purchased No



Bolt

110 Each 414.0000 2 2

Location Loc Qty Loc Code

ST358 414  
115159 414

AN4-22A Purchased No



Bolt

110 Each 201.0000 5 5

Location Loc Qty Loc Code

ST359 201  
111965 2  
114523 99  
114784 100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 62847

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN5-17A Purchased No

110 Each

86.0000

4

4



Bolt



10/10/2010

LocationLoc QtyLoc Code

ST339

86

114784

46

115594

40

4

MS20600-AD4W3

Purchased

No

110 Each

1,569.000

2

2



Cherry Rivets



10/10/2010

LocationLoc QtyLoc Code

ST321

1569

107939

822

111636

747

2

AN960JD416

NAS1149D0463J

Purchased

No

110 Each

24.0000

14

14



Washer



11/15/2010

LocationLoc QtyLoc Code

ST300

24

113288

24

AN960JD516

NAS1149D0563J

Purchased

No

110 Each

34.0000

4

4



Washer



11/14/2010

LocationLoc QtyLoc Code

ST

34

103694

18

107534

12

109287

4

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Page 4

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 62847

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD8 NAS1149DN832 Purchased No

110 Each

10.0000

2 2



Washer



1115832 10/10/2010

Location

Loc Qty

Loc Code

ST347

10

105059

10

NAS1515H4 Purchased No

110 Each

97.0000

2 2



Washer



10/10/2010

Location

Loc Qty

Loc Code

ST277

97

111294

5

111525

92

MS21042L3 Purchased No

110 Each

2,546.000

2 2



Nut



10/10/2010

Location

Loc Qty

Loc Code

ST300

2546

114523

49

114784

1497

115835

1000

2

Tuesday, October 12, 2010 11:41:42 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-607-043A



Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,122.000

7



7  
10/12/2010

Nut

Location

Loc Qty

Loc Code

ST300

4122

113422

68

114523

8

114718

16

114784

32

115108

998

115589

1900

115621

1100

7  
10/12/2010

MS21042L5

Purchased

No

110

Each

895.0000

4



4  
10/12/2010

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

869

115156

369

115594

500

4  
10/12/2010

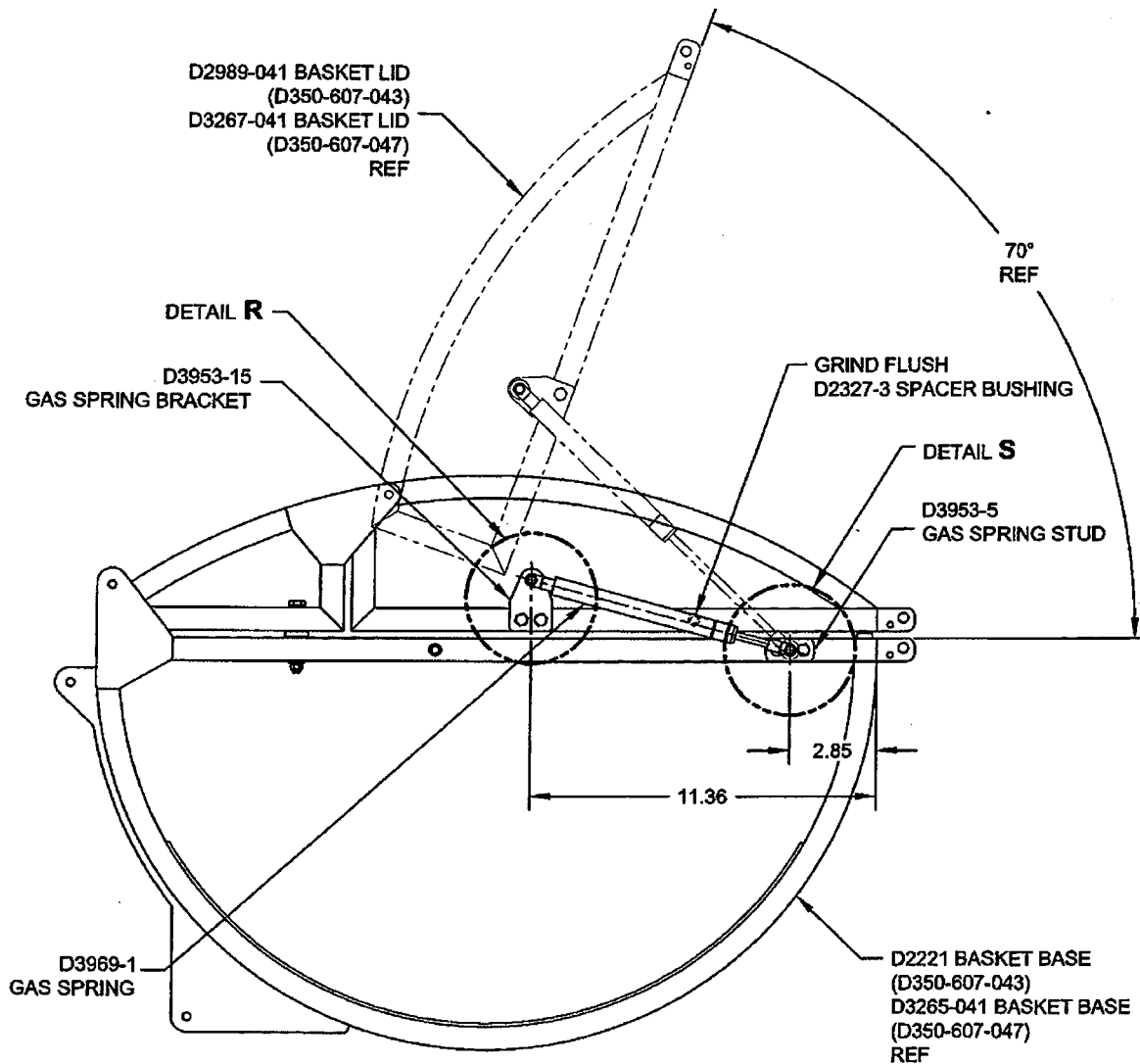
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**NOTE:** Date & initial all entries



**D350-607-143 AUTOMATIC LID OPENER INSTALLATION**  
(1 END ONLY)

**Figure 9a – Automatic Lid Opener Installation**

SHOP COPY

REVISION

FIG. 9a

UNCONTROLLED COPY

SUBJECT TO THE TERMS OF

AGREEMENT

NO. 10847

10-10-12

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Revision: **A**  
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.  
**NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.  
**NOTE:** With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

#### 4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

**NOTE:** This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- u/o 42897 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.  
**NOTE:** The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.  
**NOTE:** With the lid in the closed position the Gas Spring should not be fully compressed.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

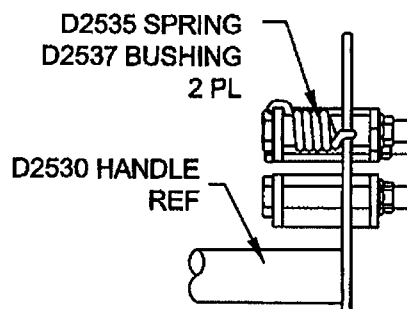
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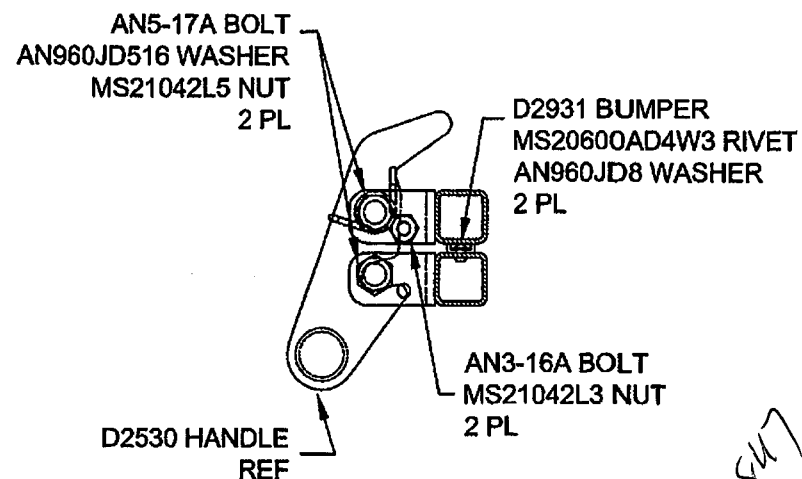
DART AEROSPACE LTD.

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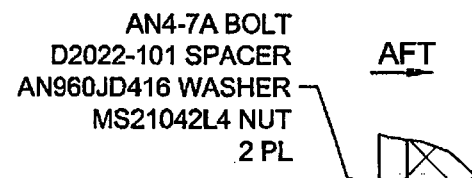
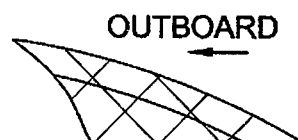


SPRING DETAIL



LATCH DETAIL

DETAIL J:  
HANDLE WELDMENT



*W/62847*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

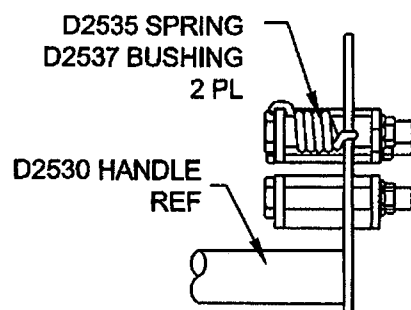
**NOTE:** Date & initial all entries



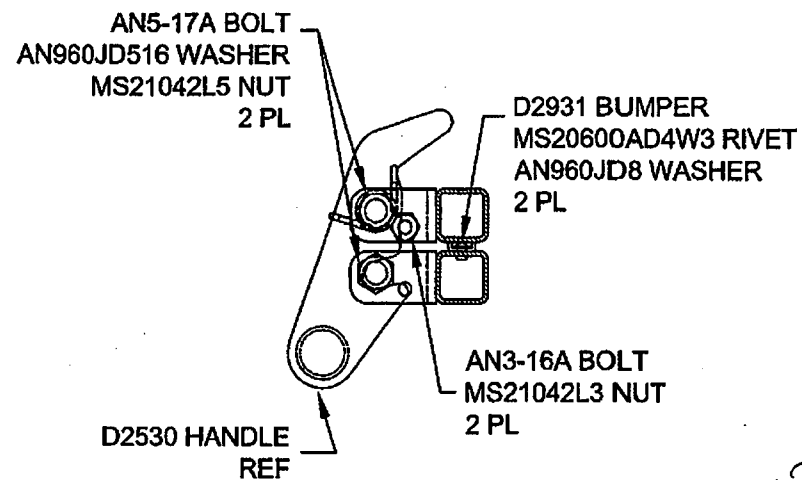
DART AEROSPACE LTD.

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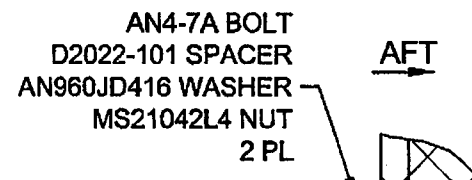
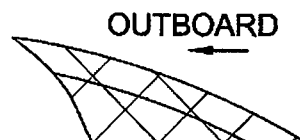


SPRING DETAIL



LATCH DETAIL

DETAIL J:  
HANDLE WELDMENT



*01662847*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries